

Work Order ID 50014

July 2, 2009 3:43:59 PM



Page 1

Item ID: D2224

Accept

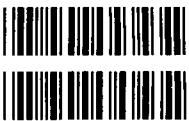


Setup Start



Revision ID: E

Stop



Item Name: Rappel Anchor

Start Date: 07/06/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**

Draw Nbr

Revision Nbr

D2224

Rev E

100



BAND SAW

Bandsaw

DTP 09/07/09

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 2.8" | *****Note grain direction *****

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

DTP 09/07/09

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio D2224 & Dwg D2224|2-Deburr & Tumble

120



QC2- Inspect parts off machine FAI/FAIB

QC

DTP 09/07/09

Memo

0.00

Quality Control

0.00

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July 2, 2009 3:43:59 PM



Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Start



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

→ Sorboho

(10)

140



Outsource4

Outsource process-Anodize per QSI017 4.1.10.1

0.00

CY 09/07/13 10

Outsource process - Anodize

Memo

0.00

Issue P/O: 10059 Red Anodize as per Dwg D2224 MIL-A-8625

150



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

PC 9/1/22 (10)

Work Order ID 50014

July 2, 2009 3:43:59 PM



Page 3

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Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ 29/07/23

410

f

170



Packaging

Packaging

Identify as per dwg & Stock Location: 489

0.00

Peggy

(1)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

29/07/27

K9.874

Picklist Print

July 2, 2009 3:43:58 PM

Page 1

Work Order ID: 50014



Parent Item: D2224RevE



Parent Item Name: Rappel Anchor

Start Date: 07/06/2009

Required Date: 07/15/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No			100	f	5.3300	2.3263			

7075-T73 Bar 2.50 x 3.25



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Main Warehouse

MAT	5.33
102694	5.33

DJP
09/07/09

2.3263

DART AEROSPACE LTD	Work Order:	b50014
Description: Rappel Anchor	Part Number:	D2224
Inspection Dwg: D2224	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	DJP	Audited by:		Prototype Approval:	N/A
Date:	09/07/06	Date:	02/07/07	Date:	N/A

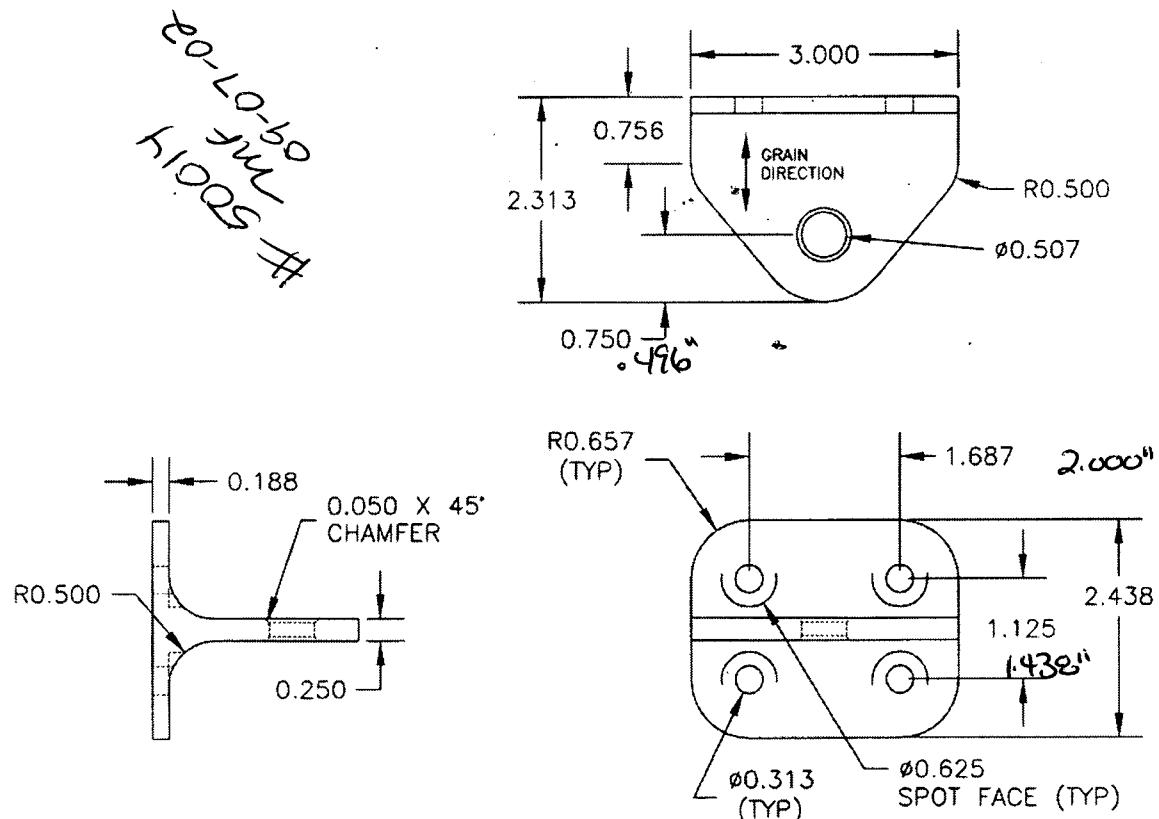
Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	

DART



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED
99.04.29 KE



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
 FINISH : ANODIZE RED PER MIL-A-8625
 BREAK ALL UNMARKED EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 certified
 approuvé NADCAP approved

76460

7/21/2009

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY , ONTARIO
 K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

NO. DE COMMANDE: PO10059
PURCHASE ORDER/



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	10	10	D2224 ✓ B50014	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
1	4	4	D2313 B40582	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Sorlo723

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager